

Work Order ID 73624

Wednesday, September 07, 2011 2:40:25 PM



Page 1

Item ID: D3463-7

Accept



Setup Start



Revision ID:

Item Name: Drag Arm

Start Date: 9/14/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 9/21/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan:



Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3463

Rev B

100



Small Fab

Small Fab

0.00

Small Fab

Small Fab

Memo
1-Cut to 13.875"
2-Deburr
3-Bend end as per dwg D3463

Ae 11-01-02

SB 11/11/02

110



QC5- Inspect part completeness to step on W/O

0.00

QC

Quality Control

S ululus

x/o

120



CONVENTIONAL MILLING MACHINE

0.00

Mill Conv

Conventional Milling Machine

Memo

0.00

1-Mill as per dwg D3463
2-Drill hole & ream to 0.4385" as per dwg D3463
3-Deburr

11/11/09

10

* Check your length before machining contours end ! *

SMW/JF

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 73624

Wednesday, September 07, 2011 2:40:25 PM



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Item ID: D3463-7

Accept



Setup Start



Revision ID:

Stop



Item Name: Drag Arm

Start Date: 9/14/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 9/21/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



QC

QC2- Inspect parts off machine FAI/FAIB

0.00

11/11/09

10 0

Quality Control

140



QC

QC8- Inspect parts - second check

0.00

11/11/10

10 0

Quality Control

150



Small Fab

Small Fab

0.00

Memo

0.00

Grind .450" rad

+ Remove all markings off arm.
11/11/09

Ac 11-12-05

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 73624

Wednesday, September 07, 2011 2:40:25 PM



Page 3

Item ID: D3463-7

Accept



Setup



Start



Revision ID:

Item Name: Drag Arm

Start Date: 9/14/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 9/21/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run



Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00
8/12/06

(40)

170



Packaging

Packaging

Identify as per dwg & Stock Location: WA

0.00

10/12/06 (10)

Memo

WA

0.00

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/12/06 (10)

MC
11-12-06

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, September 07, 2011 2:40:22 PM

Page 1

Work Order ID: 73624



Parent Item: D3463-7



Parent Item Name: Drag Arm

Start Date: 9/14/2011

Required Date: 9/21/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP REV> A 05.11.18 new issue EC
IPP Rev:B Added Step 7 08-11-04 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TR0.750W.120		Purchased	No			100	f	56.0000	1.15625	12.17105			

304 ss round tube .750 x .120w



Location	Loc Qty	Loc Code
MAT017 <u>M119160</u>	56.00000027	<u>6.1</u>
114706	0.00000027	
<u>118390</u>	56	<u>5.9</u>

Ac 11.11.02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD

Work Order: 73624

Description: DRAG ARM

Part Number: 3463-7

inspection Dwg: 23463 Rev: B

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Measured by:

Audited by: B.E

Prototype Approval:

Date: 11/11/09

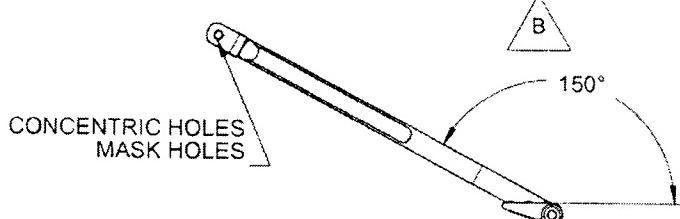
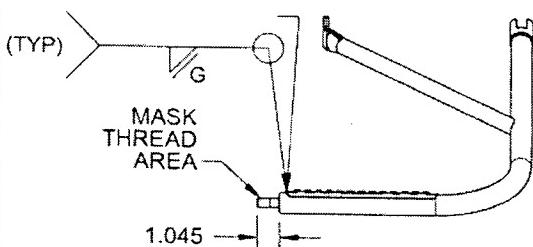
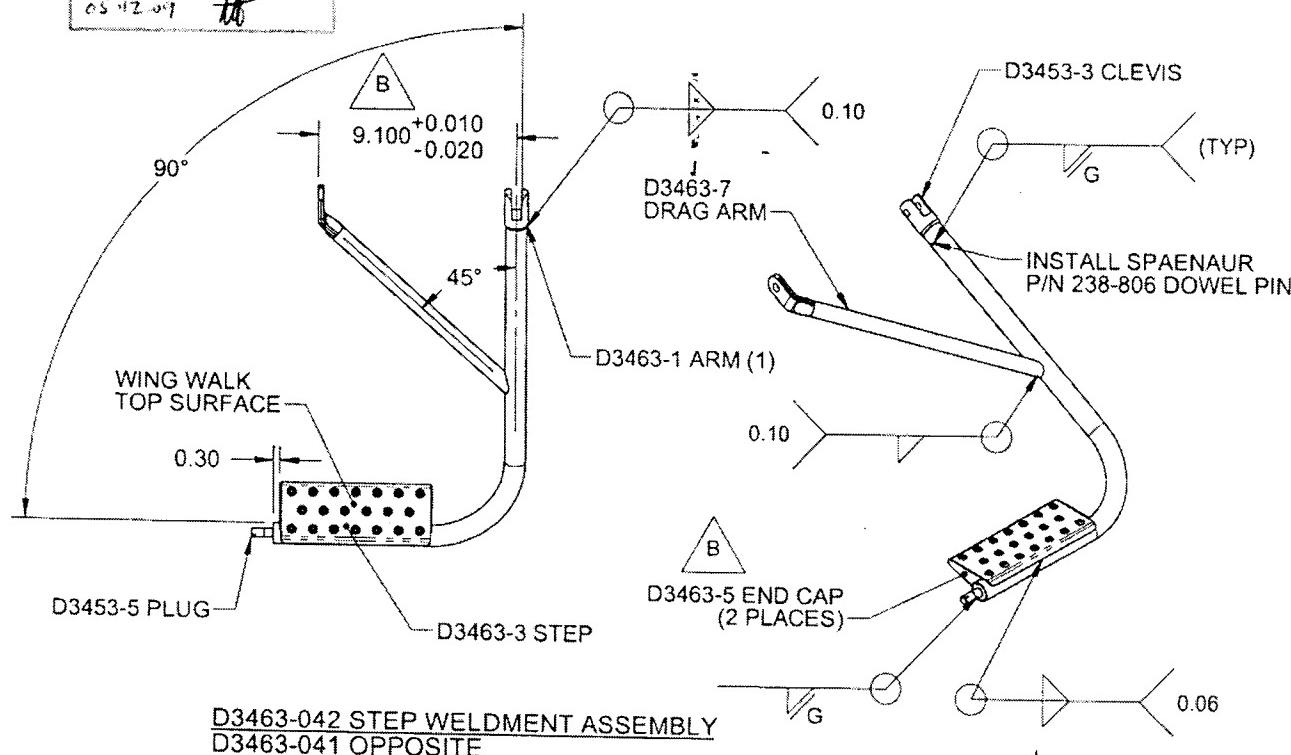
Date: 11/11/10

Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>MM</i>	APPROVED <i>MM</i>	DRAWING NO. D3463
DATE 05.12.05	TITLE STEP WELDMENT	REV. B SHEET 1 OF 4 SCALE 1:8
A 05.09.20	NEW ISSUE	
B 05.12.05	REVISE DIM.; D3463-5 WAS D3463-5F	

INSTALL P/N 238-806
DOWEL PINRELEASED
05-12-05**NOTES:**

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

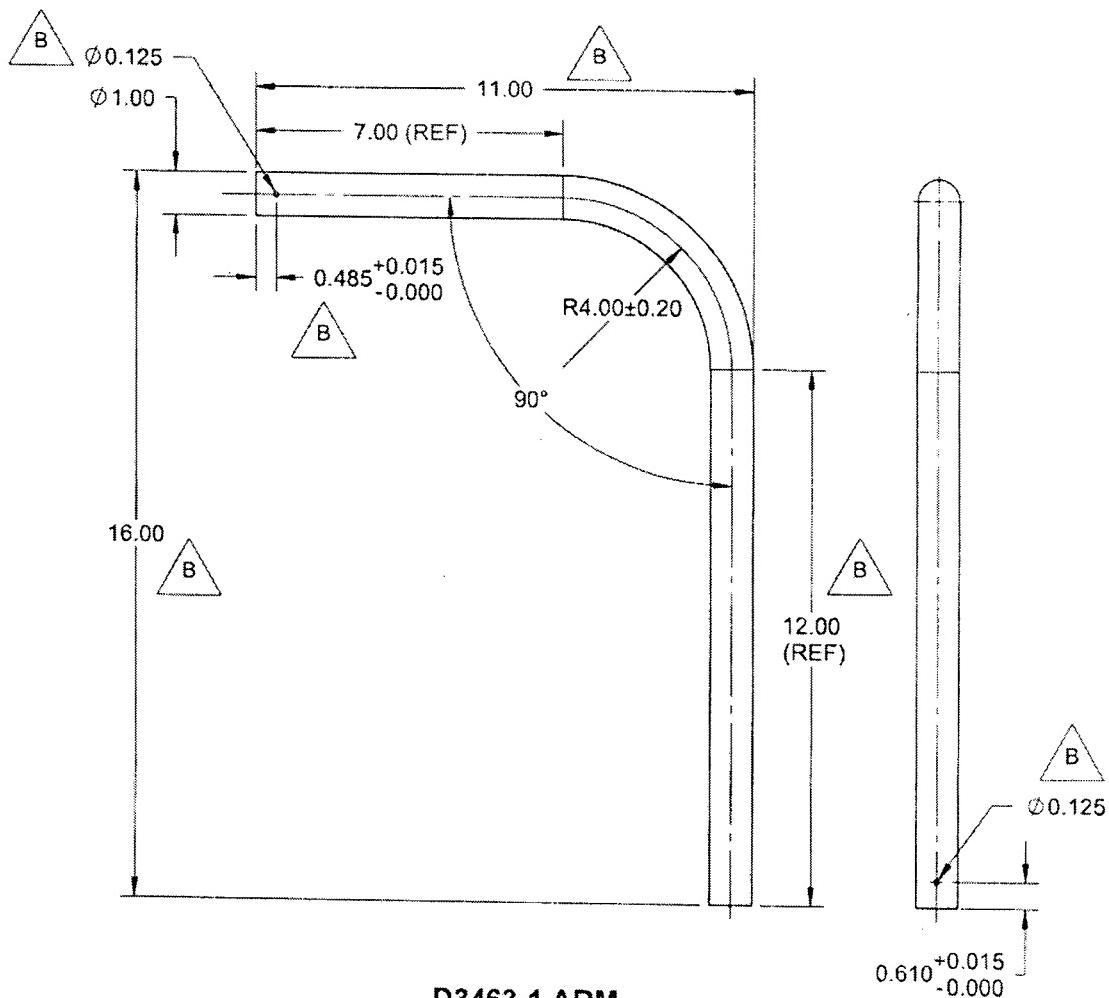
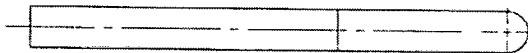
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CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D3463
DATE 05.12.05	TITLE STEP WELDMENT	REV. B SHEET 2 OF 4 SCALE 1:4

RELEASED

05.12.05 *[initials]*D3463-1 ARM**NOTES:**

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC. M304TR1.000W.120)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.025

[Signature]

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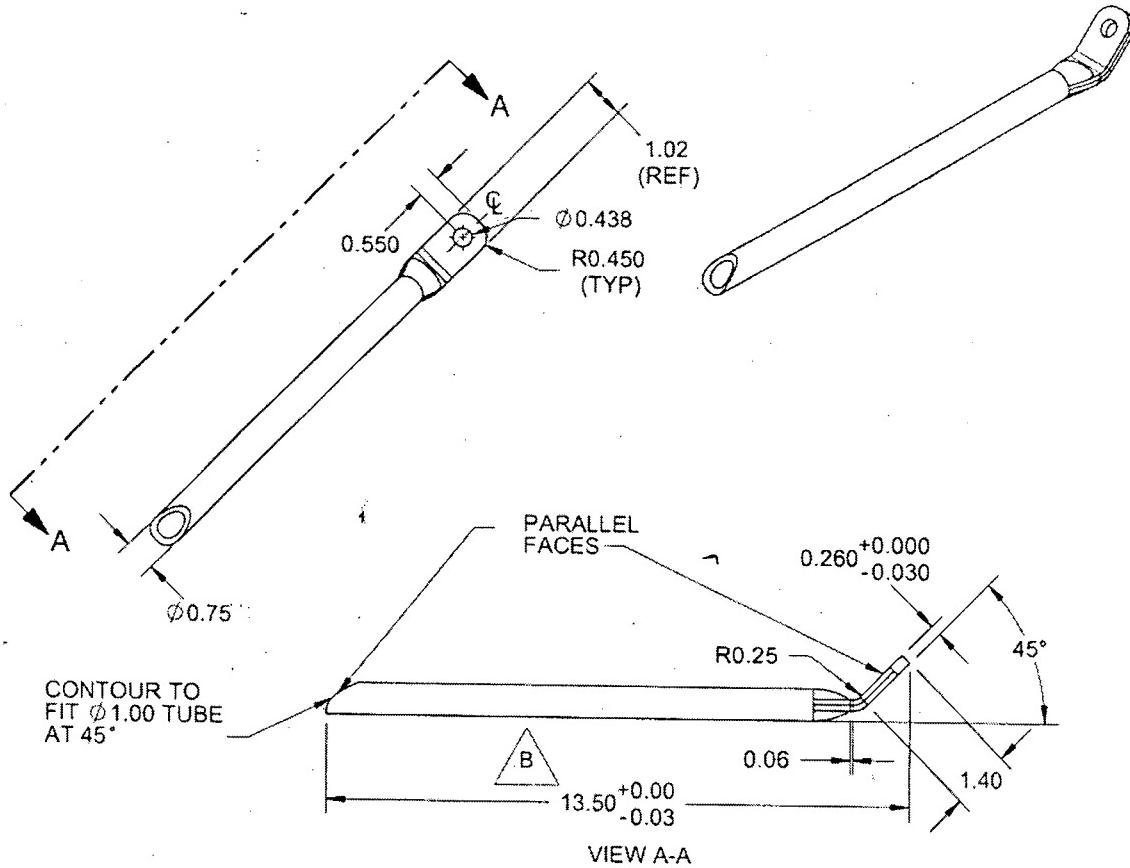
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CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D3463
DATE 05.12.05	TITLE STEP WELDMENT	REV. B SHEET 3 OF 4 SCALE 1:4

RELEASED

05.12.05

**D3463-7 DRAG ARM****NOTES:**

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC. M304TR0.750W.120)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

73624

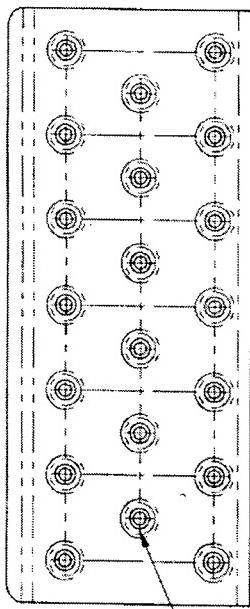
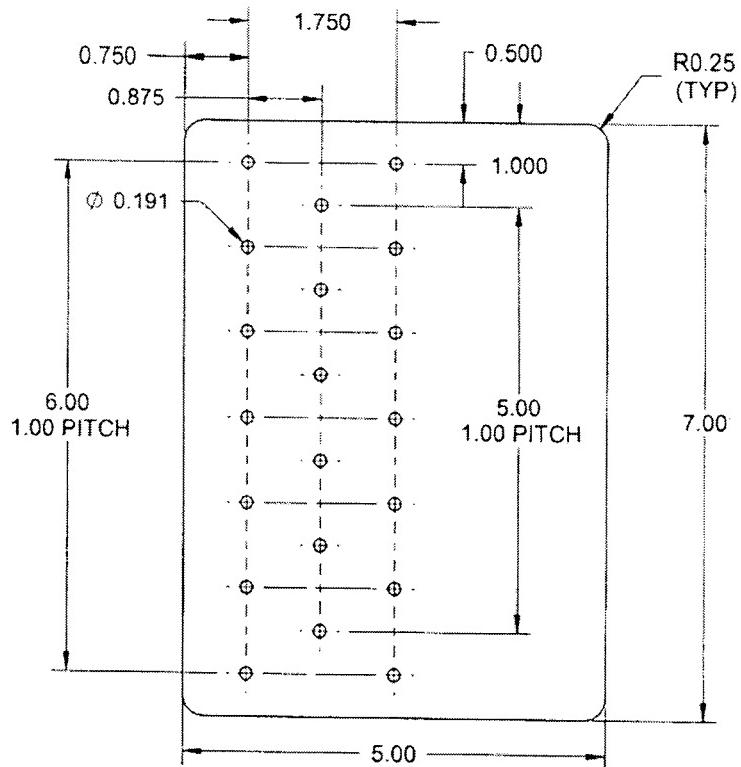
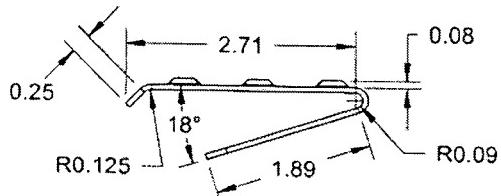
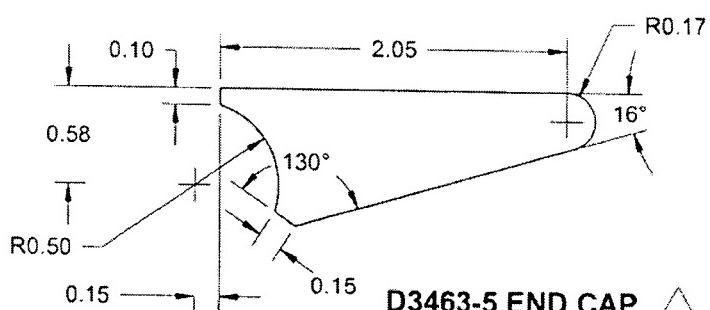
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DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>H</i>	APPROVED <i>A</i>	DRAWING NO. D3463	REV. B SHEET 4 OF 4
DATE 05.12.05	TITLE STEP WELDMENT	SCALE 1:2	

RELEASED

05.12.05 *H*FORM USING
D3463-3T1**D3463-3F FLAT PATTERN****D3463-3 STEP****D3463-5 END CAP**
SCALE 1:1**B****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.060 THICK (REF. DART SPEC. M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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